

Work Order ID 141658

March 10, 2016 2:24:31 PM

141658

Page 1

Item ID: D4406-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Wearplate Assembly
Start Date: 2/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/9/2016 Req'd Qty: 1.00 ***1*** Customer: CWILD02
Reference: RMA RA112217

Approvals: Process Plan: SH Date: 20160311 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4406	D								
100		0.00							
100									
QC	Memo	0.00							
Quality Control	INSPECT D4406-043 B128798 ON RA 112217								
	DAMAGE FOUND TO ROCKGUARD								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	TOUCH UP ROCKGUARD AS PER DRAWING D4406								
	134278								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

① 16-03-11 P11

1 DAS 41 9-89 16-3-11

① DAS 38 9-89 MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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Page 2

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Reference: RMA RA112217

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>1P-002</u>	0.00							
130									
Packaging	Memo	0.00				X1	4	16/03/11	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00						16/1/15	
Quality Control									

MCS MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 141658

141658

Parent Item: D4406-043

D4406-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 2/8/2016

Required Date: 2/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 11.06.06new issue EC verified by:DD IPP rev B
12.02.06 as per dwg revPB1 DD verf:EC IPP REV:C 15.11.16
AS PER DWG PD1 DD VERF:JLM IPP REV:D 16.02.05 AS PER
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4406-043		Manufactured	No				Each	1.0000		1			

D4406-043

Aft Wearplate Assembly

B128798

PD 16-03-15

Location

Loc Qty

Loc Code

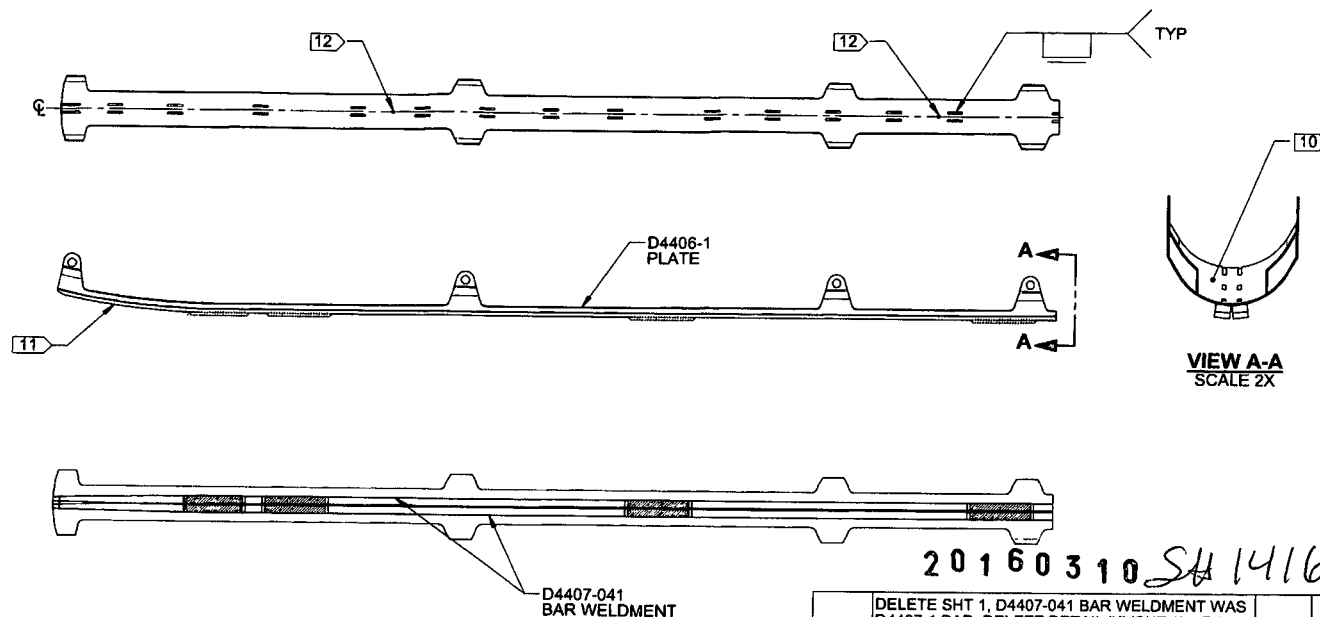
perlim

1

139175

1

ITEM	QTY	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT



D4406-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING.
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-1 TO D4407-041

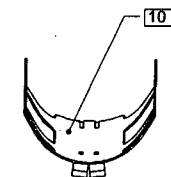
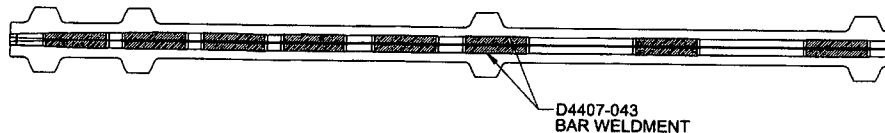
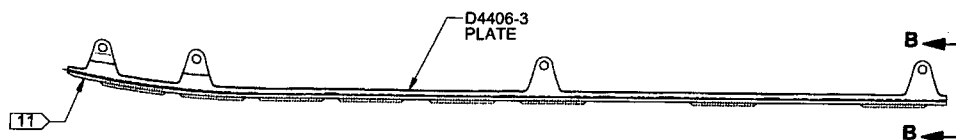
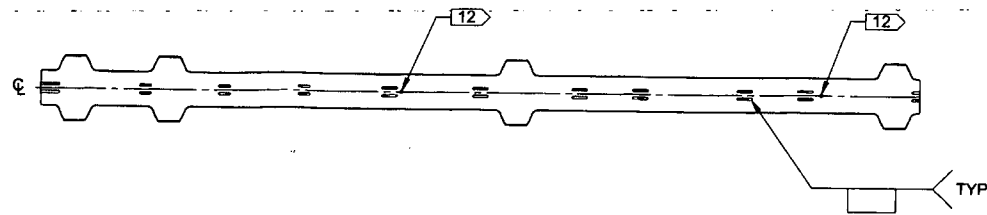
D	DELETE SHT 1, D4407-041 BAR WELDMENT WAS D4407-1 BAR, DELETE DETAIL 'K' (SHT 1), D4407-043 BAR WELDMENT WAS D4407-3 BAR, DELETE DETAIL 'L' (SHT 2), REMOVE NOTE 9 (SHT 182), NOTE 10: TEXTURED COATING WAS ROCKGUARD (SH 182), NOTE 12: D4407-041 WAS D4407-1 (SHT 1), D4407-043 WAS D4407-3 (SHT 2), REMOVE NOTE 13 (SHT 182)	DB	15.10.14
C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED, SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031)	AJS	13.03.11
B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2&3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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RELEASED
2016-02-08
EEN 16-51B

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D4406-043	WEARPLATE ASSY
1	1	D4406-3	PLATE
2	2	D4407-043	BAR WELDMENT

△ D



VIEW B-B
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

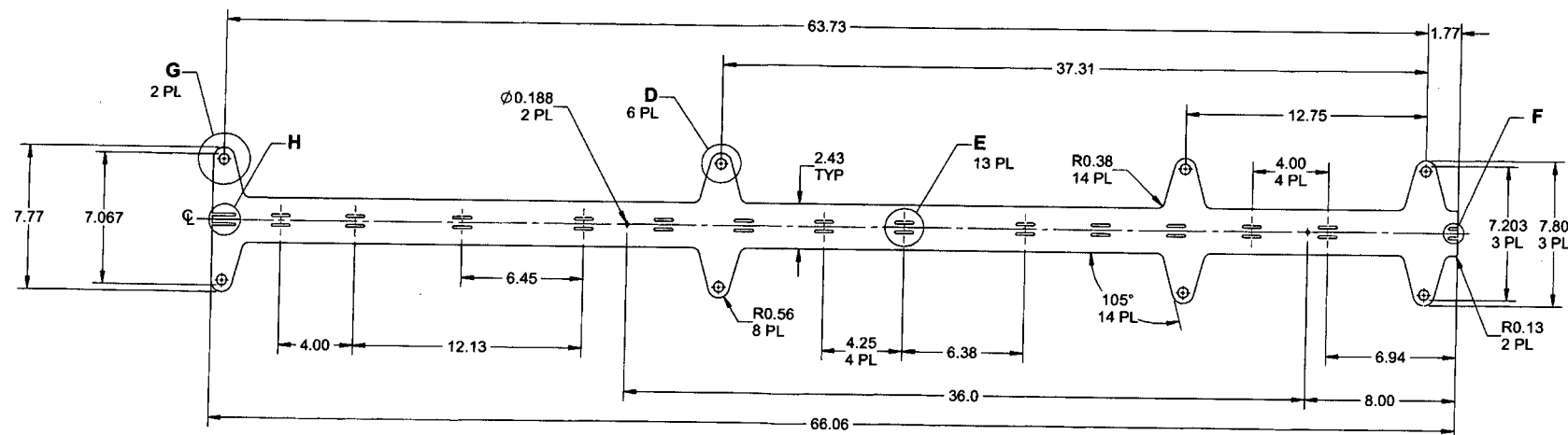
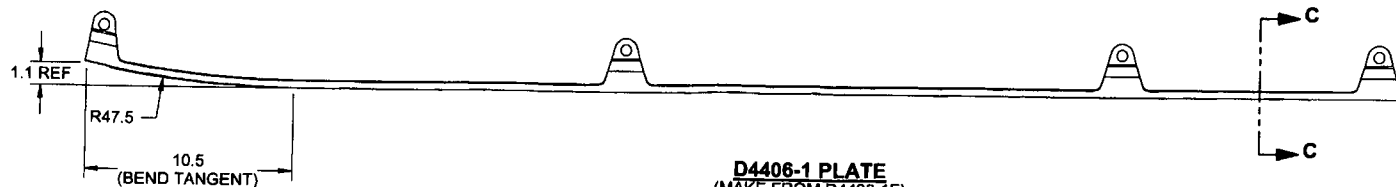
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 8.1
- 7) WEIGHT: 8.70 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING.
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-043

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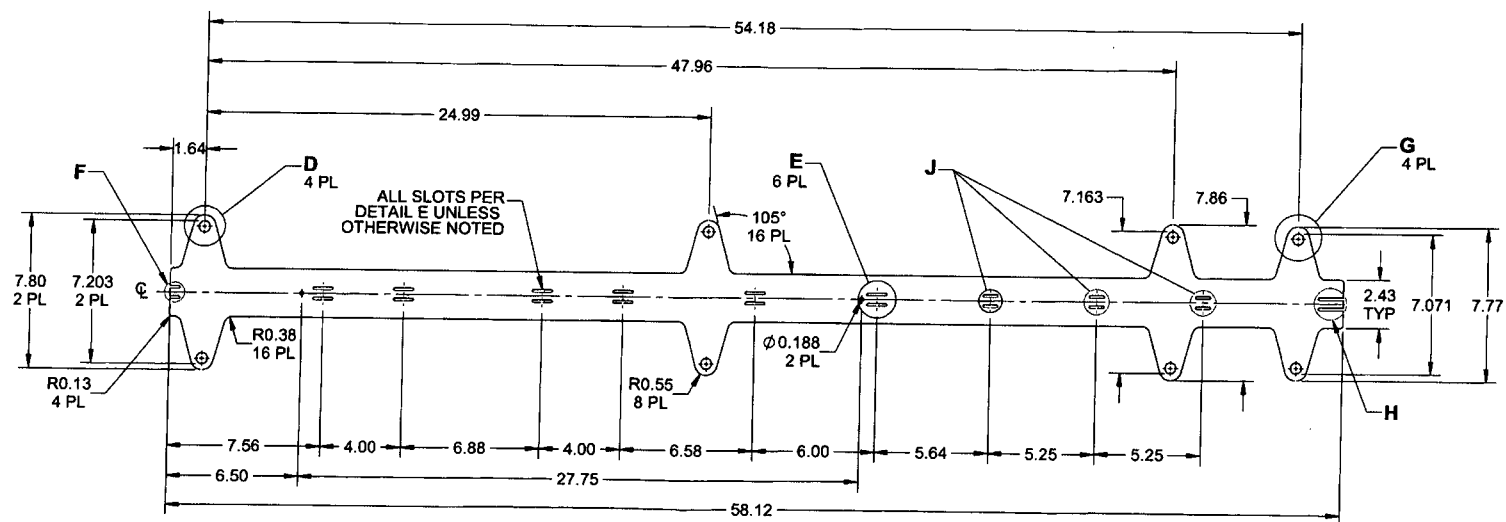
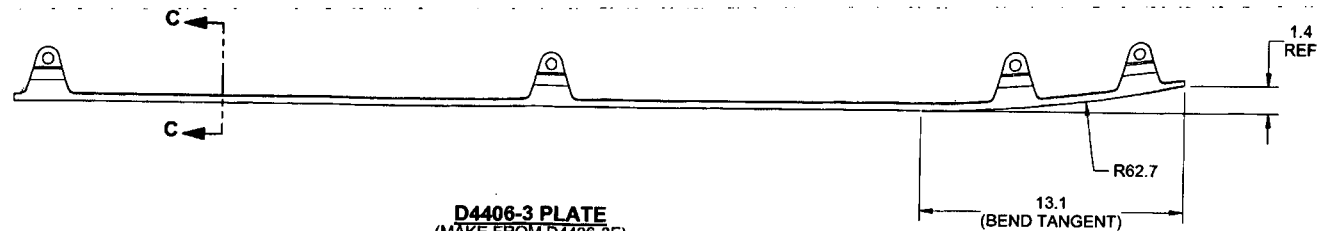
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

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8 7 6 5 4 3 2 1



NOTES:

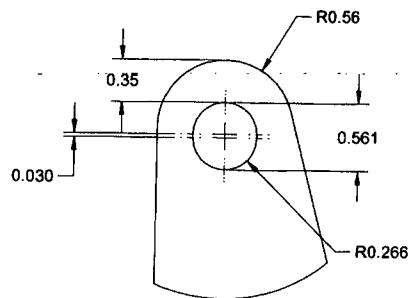
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.5 lbs

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2016-02-08

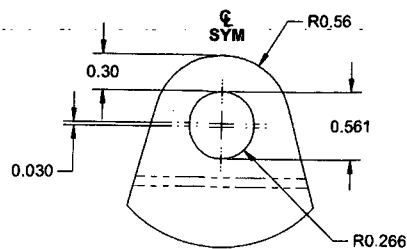
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MFG. APPR.	DD	D4406	SHEET 4 OF 5
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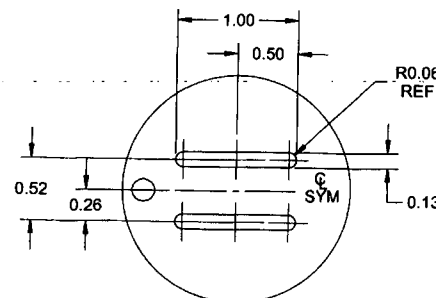
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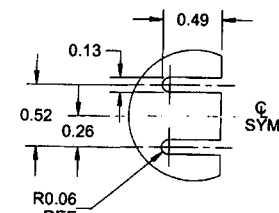
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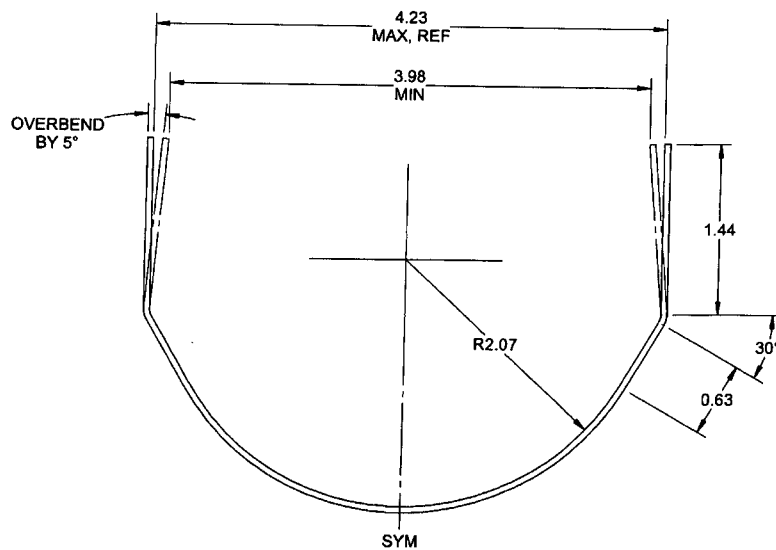
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SCALE 6X



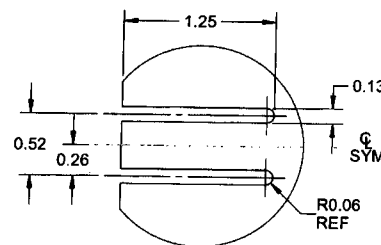
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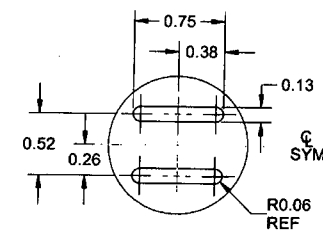
DETAIL F
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL H
SCALE 6X



DETAIL J
SCALE 6X

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2016-02-08

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MFG. APPR.	DD	D4406	SHEET 5 OF 5
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